



## HOLEX Pro Steel solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7 (mm or inch): 3,9 mm or inch



### Order data

Order number	122507 3,9
GTIN	4045197831743
Item class	12F

### Description

#### Version:

**Straight major cutting edges** and a **special flute profile** ensure good chip evacuation. The robust cutter geometry ensures high-performance drilling with good process reliability.

A wide range of applications in steel materials thanks to a combination of tough ultra-fine grain carbide and extremely wear-resistant coating.

#### Recommendation:

##### Maximum drilling depth:

clamping slot length (see table) less  $1.5 \times \text{nominal } \varnothing$ .

##### Note:

Flute length  $L_c = L_2 + 1.5 \times D_c$ .

Machining strategy: HPC

Standard: DIN 6537 K

Tolerance nominal  $\varnothing$ : h7

Number of cutting edges Z: 2

Tolerance nominal  $\varnothing$ : h7

recommended maximum drilling depth  $L_2$ : 18.2 mm

Overall length L: 66 mm

Shank  $\varnothing D_s$ : 6 mm

Feed f in steel  $< 900 \text{ N/mm}^2$ : 0.11 mm/rev.

### Technical description

Feed f in steel $< 900 \text{ N/mm}^2$	0.11 mm/rev.
recommended maximum drilling depth $L_2$	18.2 mm
Standard	DIN 6537 K

Number of cutting edges Z	2
Overall length L	66 mm
Shank $\varnothing D_s$	6 mm
Flute length $L_c$	24 mm
Tolerance nominal $\varnothing$	h7
Nominal $\varnothing D_c$	3.9 mm
Series	HOLEX Pro Steel
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	4×D
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, to 25 bar
Machining strategy	HPC
Colour ring	green
Type of product	Jobber drill